

(C)

PLOT SCALE:

1=1

DWG. SCALE: 1

A12633

D

C

B

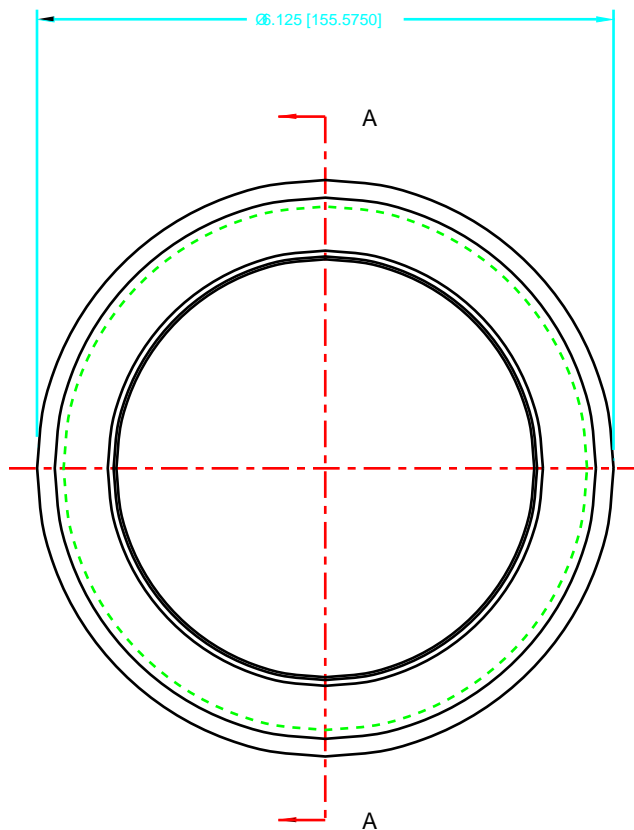
A

D

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B

A



NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
A) CIMCOOL 5 STAR 49
B) TRIM SOL
2. THIS IS A UHV PART, ELECTROPOLISHING IS NEEDED. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS

1	Ø.628 [117.48] WAS Ø.566 [115.98]				
1	Ø.500 [114.30] WAS Ø.438 [112.73]				
1	Ø.440 [112.78] WAS Ø.378 [111.20]	M.J.M.			
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE	
REVISIONS					

Ø.750 [146.0500]

Ø 4.628 [117.55]

Ø 4.500 [114.30]

Ø.440 [112.78]--001 [0.0254]

6X R.031 [.7938]

.156 [3.9624]

Ø5.562 [141.2748]

.031 [0.7874]

.030 [0.7620]

.63 [15.8750]

.125 [3.1750]

SECTION A - A

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES DECIMALS .X - .03 .XX - .01 .XXX - .005 ANGULAR - .25 SURFACE ROUGHNESS ✓ REMOVE ALL BURRS AND BREAK SHARP EDGES .05 MAX. SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1 DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5 DO NOT SCALE DRAWING				
LOG NUMBER A12633		THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
DRAWN BY MUSCIA	DATE 8/3/92	CHIEF DESIGN ENGINEER D. SHU	DATE 2/3/93	TITLE ADVANCED PHOTON SOURCE P1 1 ST PHOTON SHUTTER UPPER BELLOWS FLANGE
CHECKED BY		GP LEADER T. M. KUZAY	DATE 2/3/93	
DESIGNER MUSCIA		PROJECT MGR.		
RESPONSIBLE ENGINEER D. SHU	DATE 2/3/93	APPROVED/RELEASED		
MATERIAL 304 STAINLESS STEEL		SCALE 1:1 SHEET 1 of 1		
		SIZE C		
		DRAWING NUMBER P4102010103-210201-01		